Dart Aerospace Ltd. Thursday, 05/06/2008 9:08:55 AM Date: User: Jean-Luc Menard **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : TUBE Customer Job Number : 39717 **Estimate Number** : 11175 **Part Number** : D22825 P.O. Number - D2282 REV E : 05/06/2008 S.O. No. : **Drawing Number** This Issue : N/A Prsht Rev. : NC Project Number : MACHINED PARTS : E First Issue : 05/06/2008 **Drawing Revision** : 38641 **Previous Run** Material 20 Um: **Due Date** : 12/06/2008 Qtv: Written By Checked & Approved By Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM Additional Product Job Number: Seq. #: **Machine Or Operation:** Description: 1.0 M304R0750 3/4" 304 SS Roundbar Comment: Qtv.: 0.1891 f(s)/Unit Total: 3.7813 f(s) Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch 106 85 M1043 DOOSAN LATHE 2.0 DOOSAN LATHE Comment: DOOSAN LATHE -Turn as per Dwg D2282 and Folio FA189 2-Deburr 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

Comment: SECOND CHECK

5.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

PACKAGING RESOURCE #1





Each

Date: Thursday, 05/06/2008 9:08:55 AM User: Jean-Luc Menard

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 39717

Part Number: D22825

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

108, da 06

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART AEROSPACE LTD	Work Order:	39717
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.17				
R0.063	+/-0.010	,063				
0.063	+/-0.010	.063				
0.125	+/-0.010	.063 .125 .090 x48				
0.090 x 45°	+/-0.010	090 x45				
R0.350	+0.010/-0.000	1 350				
0.158	+/-0.010	,158				
Ø0.386	+0.005/-0.000	,387				
Ø0.700	+/-0.010	,704				
					ŀ	
·						

Measured by: Audited by: Audited by: Prototype Approval: N/A

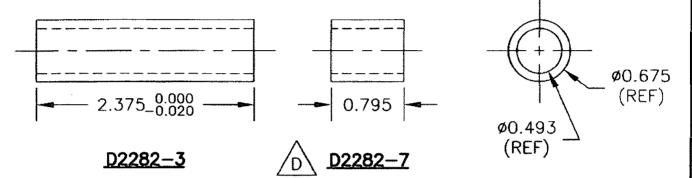
Date: 08/06/05

Date: 08/06/05

Date: N/A

Date	Change	Revised by	Approved
03.11.11	New Issue P/O D350-615-041	KJ/RF	
05.04.19	Dimensions & tolerances changed	KJ/JLM	
06.03.15		KJ/JLM , ,	
		KJ/EC/DD	1 2
	03.11.11	03.11.11 New Issue P/O D350-615-041 05.04.19 Dimensions & tolerances changed 06.03.15 Dimensions & tolerances revised per Dwg Rev E	03.11.11 New Issue P/O D350-615-041 KJ/RF 05.04.19 Dimensions & tolerances changed KJ/JLM 06.03.15 Dimensions & tolerances revised per Dwg Rev E KJ/JLM

DAY TO	DESIGN BW	DRAWN BY		AEROSPACE LTD ESBURY, ONTARIO, CANADA		
	CHECKED	O APPROVED	DRAWING NO.	REV. E		
	И	LECO	D2282	SHEET 1 OF 2		
	DATE	v	TITLE	SCALE		
	05.06.0	)7	HANDLE TUBES	5 1:		
RELASED es/e9/16	Α	94.10.14	NEW ISSUE			
	В	95.03.23	RE-DESIGN			
	С	97.10.20	CORRECTED N	IUMBERING SCHEME		
	D	05.03.16	REDESIGN D2	282-5; 0.795 WAS 0.750		
	E	05.06.07		4 SS WAS 303 SS; 63 WAS RO.080 x 0.030		



## D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED R0.063 x 0.063 DEEP  $0.090 \times 45^{\circ}$ 0.95 **CHAMFER** 0.158 Ø0.700 R0.350 -Ø0.386 0.1250.080 x 45° (REF) **CHAMFER** D2282-5

## D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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